

Date: Monday, 02/03/2009 11:26:39 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABIN DOOR ROLLER KIT, RH
Job Number	: 46209		
Estimate Number	: 10289		
P.O. Number	:	Part Number	: D412698012
This Issue	: 02/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: IIN D412-698 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 45198	Drawing Revision	: E
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 16/03/2009
Checked & Approved By	: <u>JUD 09.03.02</u>	Qty:	6
Comment	Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JUD 09/03/06



Comment: DOCUMENT CONTROL
 Photocopy bluefile and create labels per PPP D412-698-012 CHG003

508/18

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D3121141	Bracket Assembly
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3 D3121-141 Bracket Assembly

B46004 x1

B43484 x17

88 09/03/06

4.0	D3121144	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3121-144 Bracket Assembly

B43487 x1

B43604 x5

88 09/03/06

5.0	D3137043	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

B29725

88 09/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:26:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 46209

Part Number: D412698012

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly

6.0

D3183044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

1 D3183-044 Bracket Assembly

42194

8809103/06 (X6)

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total: 54.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

9 D3199-1 Bracket

B43610 X6
46006 X6

B46252 3X
B46335 3X
12/9/18

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

1 D3202-1 Cover

3X B46005 3X B46224

8809103/06 (X6)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808603/18 (X6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location:

62 Rev B 9/13/18

(X6)

50

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09103/19 (X6)

Job Completion



MF 09-03-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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 WITHOUT NOTICE
 WORK ORDER
 NO. 46209

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Revision: E
 Date: 08.05.01